

Shy April 9

Work Order ID 81719

81719

Page 1

March-19-12 8:43:12 AM

Item ID: D3340-13

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Skidtube Protector

Start Date: 29/03/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 29/03/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/19 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3340	Rev B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3340 Dwg Rev: B Prog Rev: B 2-
Deburr if necessary

B12-3-4



110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-3-4

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

Sczkel03



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81719


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Page 2

March-19-12 8:43:12 AM

Item ID: D3340-13 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Skidtube Protector
 Start Date: 29/03/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 29/03/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	NC BRAKE Memo Deburr if necessary Form on brake as per Dwg D3340 using Jigs DT 8326 and DT8261	0.00 0.00							
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
150 *150* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: 9h00 9h30 FINISH TIME: OVEN TEMPERATURE: 320°F	0.00 0.00							8 2 2P 12/04/05 m117338

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Page 3

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Item ID: D3340-13 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Skidtube Protector
 Start Date: 29/03/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 29/03/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							<u>vg f ell 12/04/04</u>
170 *170* Packaging Packaging	Identify as per dwg & Stock Location <u>50</u> Memo	0.00 0.00							<u>4/2/4/9 (S)</u>
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>CK 12/4/4</u> <u>me</u> <u>12-04-09</u>

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NOTE: Date & initial all entries

Picklist Print

March-19-12 8:43:17 AM

Page 1

Work Order ID: 81719

81719

Parent Item: D3340-13

D3340-13

Parent Item Name: Aft Skidtube Protector

Start Date: 29/03/2012

Required Date: 29/03/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: A 05.11.10 Preliminary issue AP/EC
IPP Rev:B Now on Waterjet 06-10-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S20GA		Purchased	No			110	sf	95.6700	1.258	7.945263			

M1010S20GA

1010/1025 SHEET

**

IB 12-4-3

Location

Loc Qty

Loc Code

MAT019

95.67

111410

39.2

116791

56.47

116794

18

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	81719
Description: Aft Skidtube Protector		Part Number:	D3340-13
Inspection Dwg: D3340 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.010	0.251	✓		Vern	HB-02
0.300	+/-0.010	0.305	✓		Vern	HB-02
0.50	+/-0.030	0.500	✓		Vern	HB-02
0.250	+/-0.010	0.251	✓		Vern	HB-02
2.315	+/-0.010	2.317	✓		Vern	HB-02
2.815	+/-0.010	2.815	✓		Vern	HB-02
1.625	+/-0.010	1.621	✓		Vern	HB-02
23.125	+/-0.010	23.125	✓		MT	HB-05
26.625	+/-0.010	26.625	✓		MT	HB-05
52.315	+/-0.010	52.315	✓		MT	HB-05
55.815	+/-0.010	55.815	✓		MT	HB-05
58.190	+/-0.010	58.190	✓		MT	HB-05
61.000	+/-0.010	61.000	✓		MT	HB-05
63.565	+/-0.010	63.565	✓		MT	HB-05
0.040	+/-0.010	0.035	✓		Vern	HB-02

Measured by: JM/B	Audited by: S	Preliminary Approval:
Date: 120403	Date: 7/26/03	Date:

Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ	M

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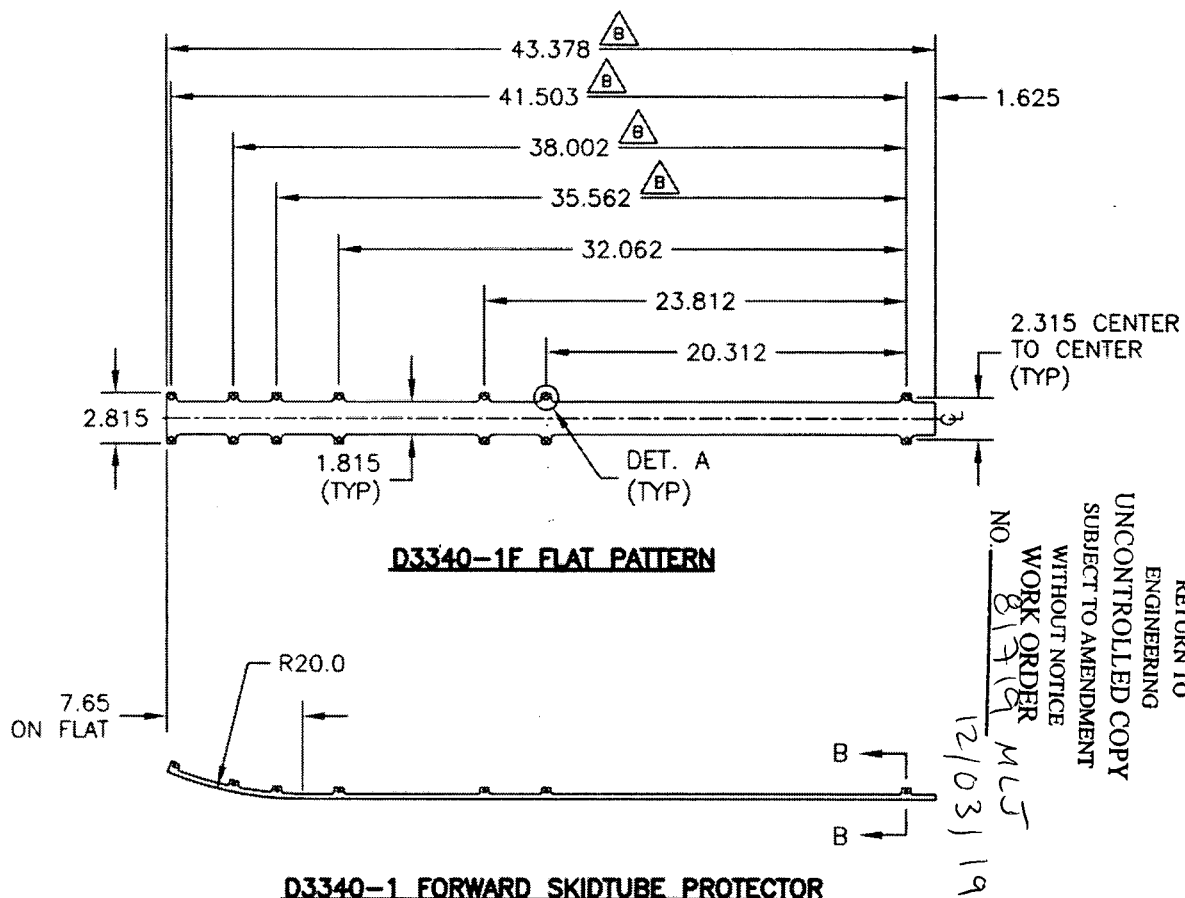
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3340	REV. B SHEET 1 OF 11
DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10
A	05.06.09	NEW ISSUE	
B	05.11.22	ADD DETAIL D, CORRECT FLAT PATTERNS D3340-1/-3/-7/-9/-13/-19/-23	

RELEASED
05.11.28



NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

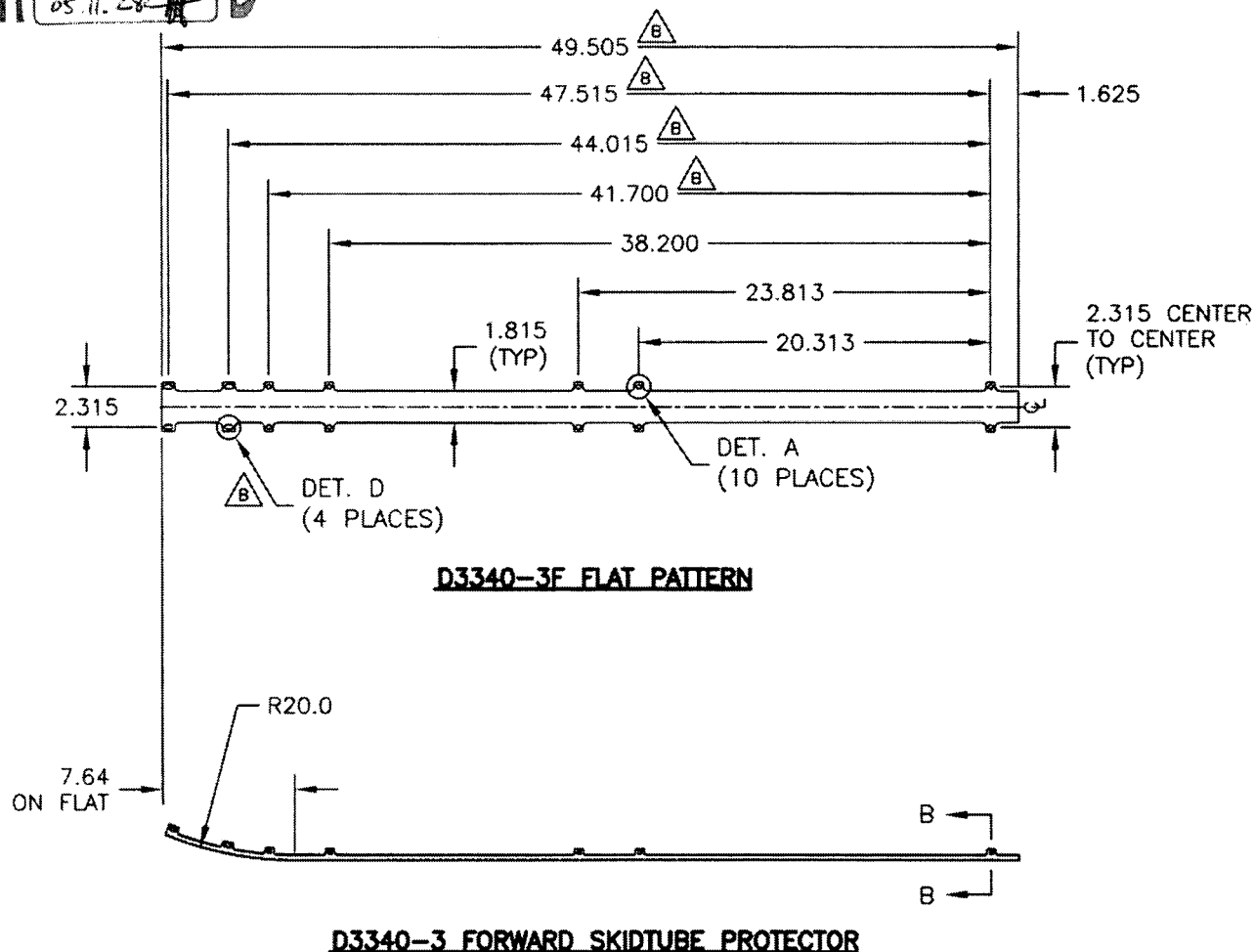
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3340	REV. B SHEET 2 OF 11
DATE 05.11.22	TITLE SKIDTUBE PROTECTOR		SCALE 1:10

RELEASED
05.11.22



NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

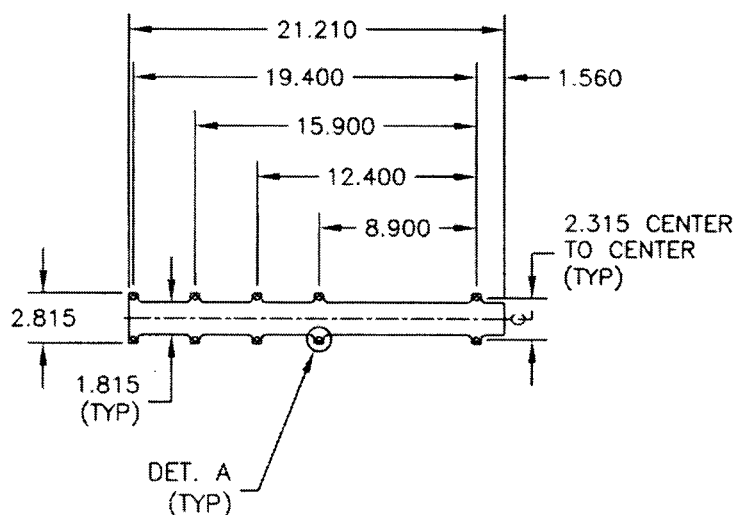
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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CHECKED #	APPROVED #	DRAWING NO. D3340	REV. B SHEET 3 OF 11
DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10

RELEASED
05.11.28 #



D3340-5F FLAT PATTERN



D3340-5 FORWARD SKIDTUBE PROTECTOR

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

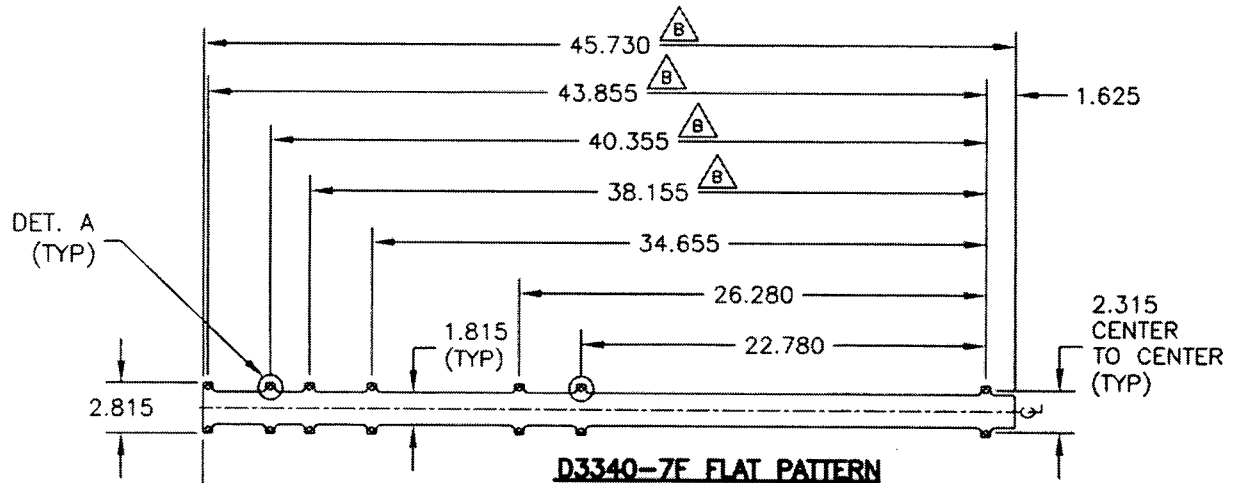
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

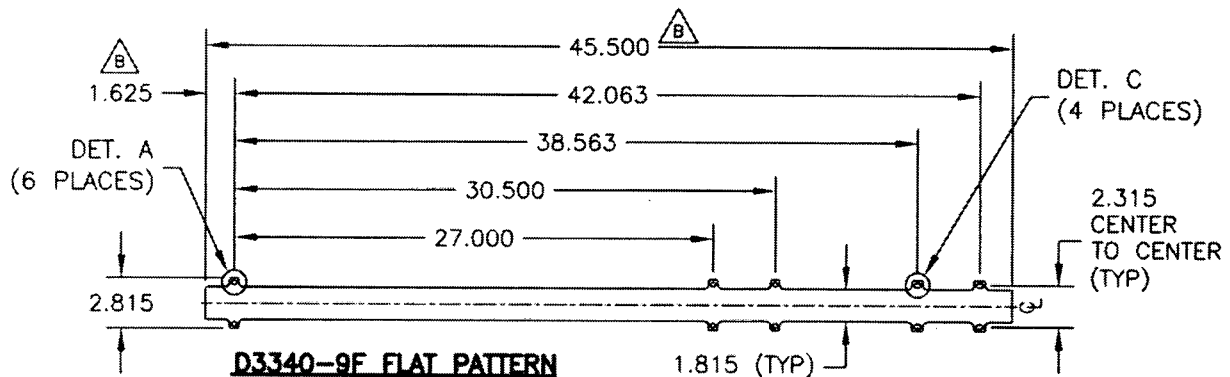
NOTE: Date & initial all entries



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CHECKED 	APPROVED 	DRAWING NO. D3340	REV. B SHEET 4 OF 11
DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10



D3340-7 FORWARD SKIDTUBE PROTECTOR



D3340-9 AFT SKIDTUBE PROTECTOR

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

RELEASED
05.11.28

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

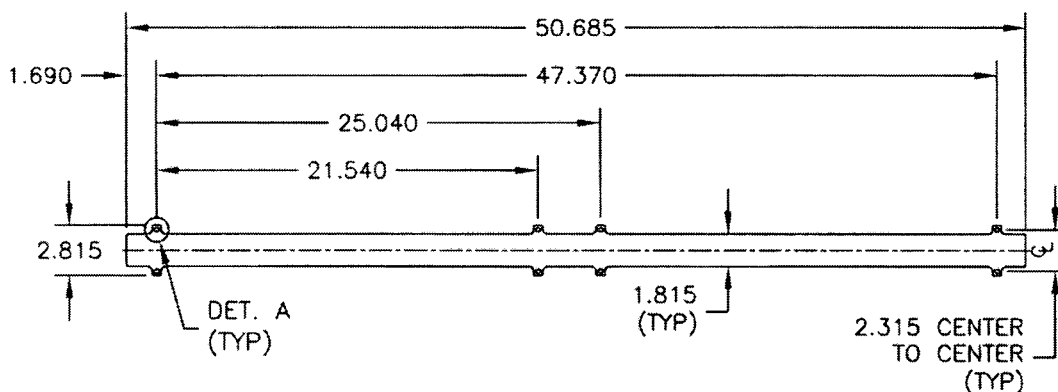
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3340	REV. B SHEET 5 OF 11
DATE 05.11.22	TITLE SKIDTUBE PROTECTOR		SCALE 1:10

RELEASED
05.11.28



D3340-11F FLAT PATTERN



D3340-11 CENTER SKIDTUBE PROTECTOR

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR
ASTM A36/A366/A1008 OR
CSA G40-21, 38W/44W/50W/60W/70W SERIES
COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6)
PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

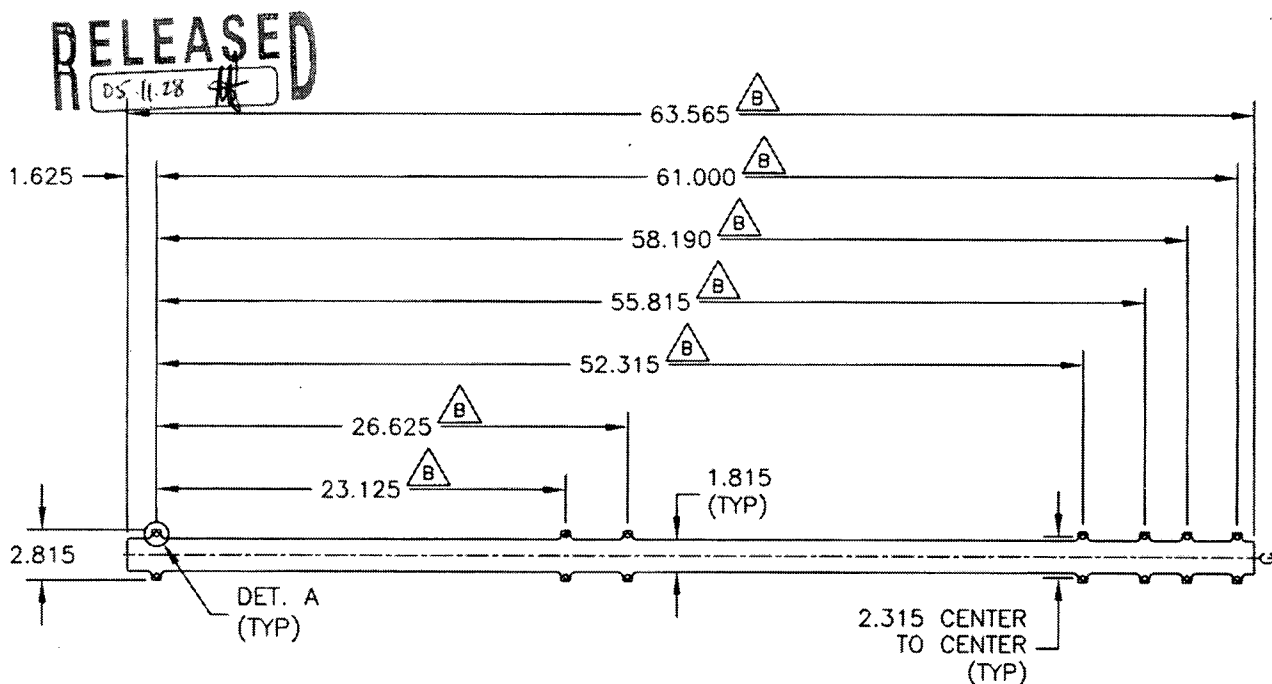
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3340	REV. B SHEET 6 OF 11
DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10



D3340-13F FLAT PATTERN



D3340-13 AFT SKIDTUBE PROTECTOR

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR
CSA G40-21, 38W/44W/50W/60W/70W SERIES
COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
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6/10
b1219

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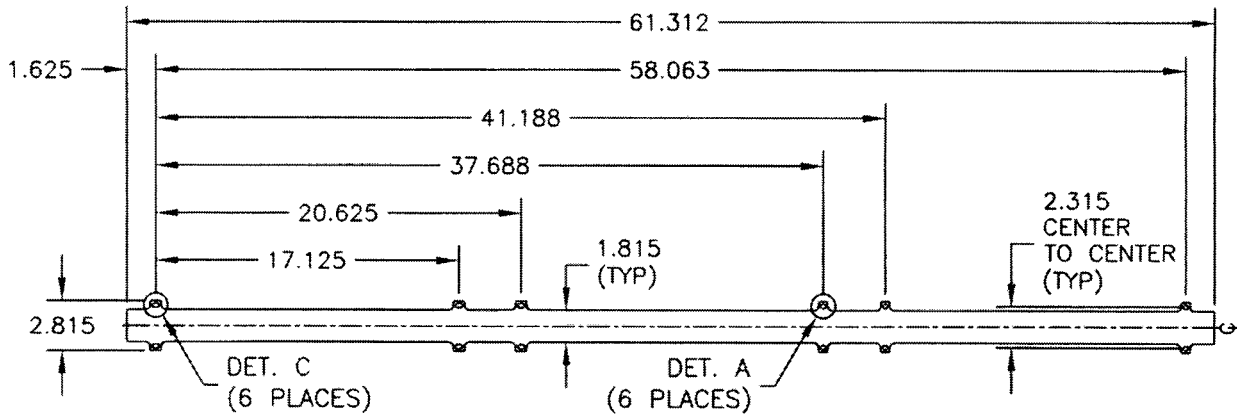
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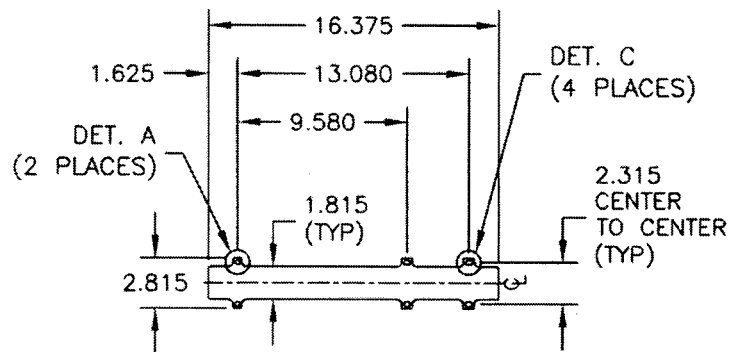
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3340	REV. B SHEET 7 OF 11
DATE 05.11.22	TITLE SKIDTUBE PROTECTOR		SCALE 1:10



D3340-15F FLAT PATTERN

RELEASED
05.11.28

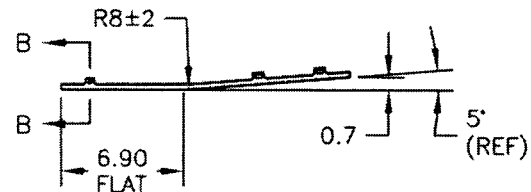
D3340-15 CENTER SKIDTUBE PROTECTOR



D3340-17F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR
ASTM A36/A366/A1008 OR
CSA G40-21, 38W/44W/50W/60W/70W
SERIES COLD ROLLED STEEL 19 GAUGE
(0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX
(REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX



D3340-17 AFT SKIDTUBE PROTECTOR

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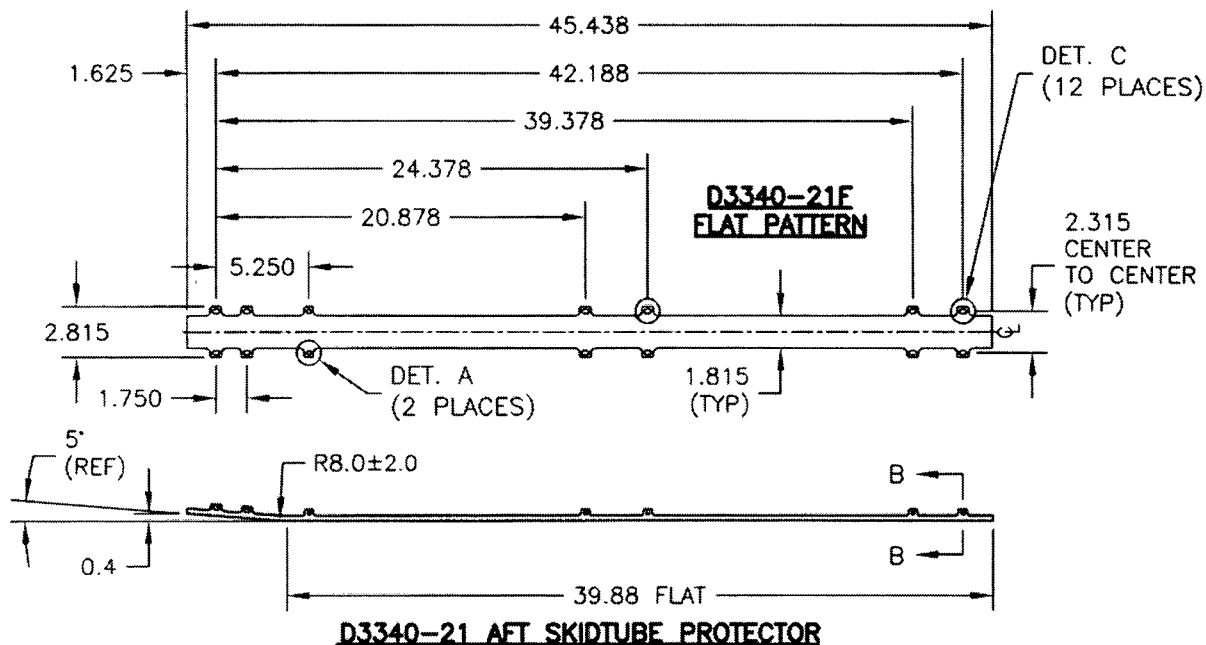
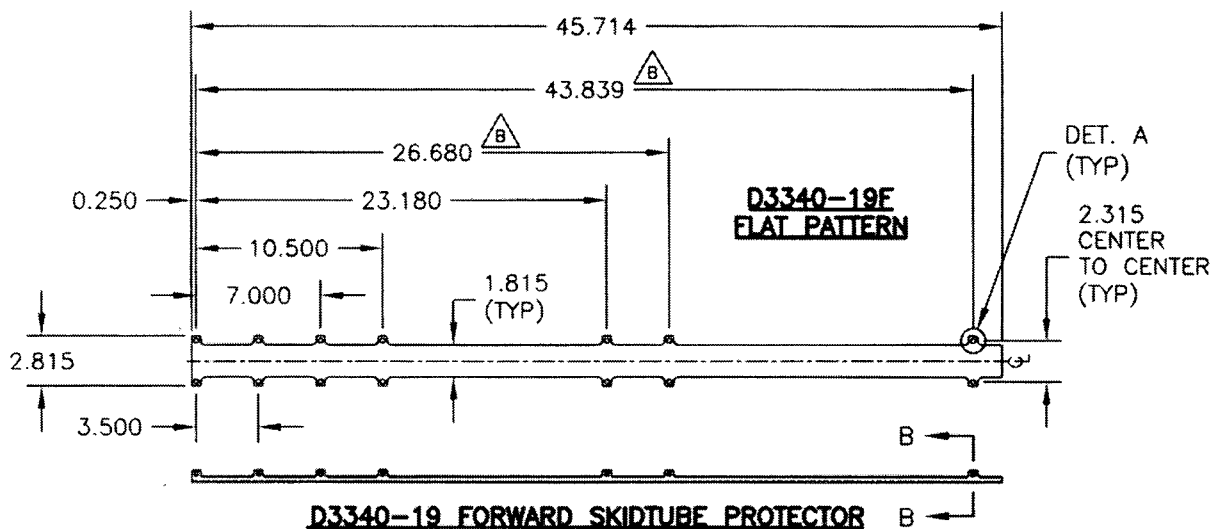
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3340	REV. B SHEET 8 OF 11
DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10



NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

RELEASED
05.11.28

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6179

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

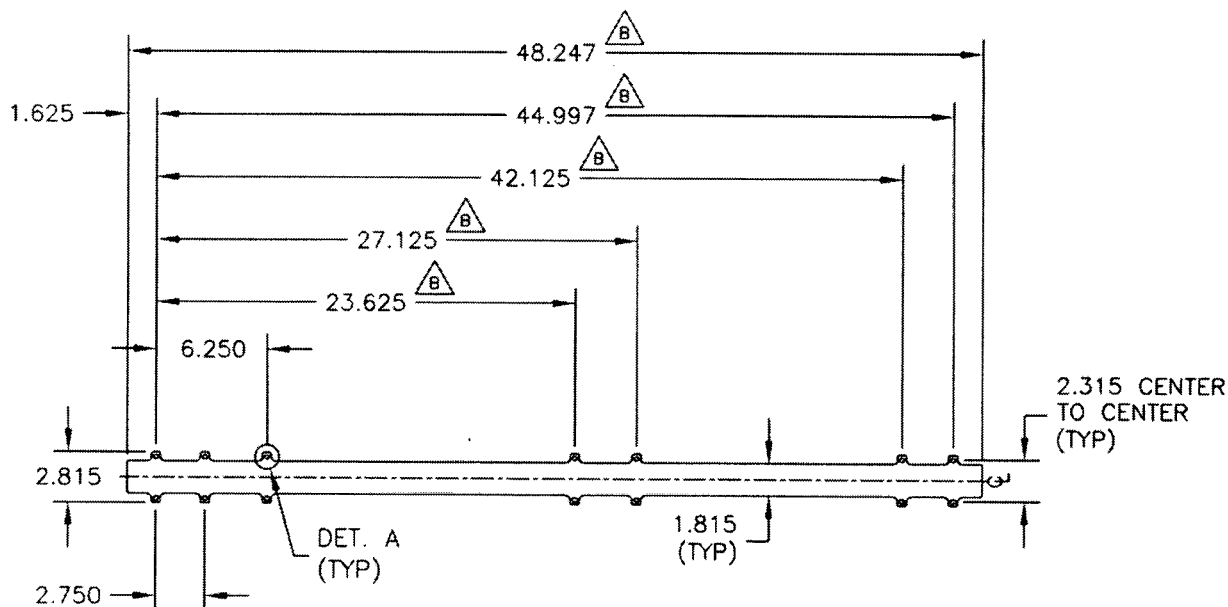
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

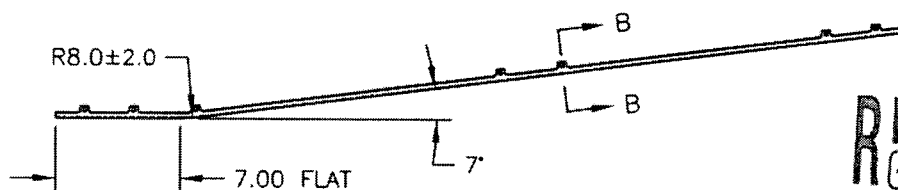
NOTE: Date & initial all entries



DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3340	REV. B SHEET 9 OF 11
DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10



D3340-23F FLAT PATTERN



D3340-23 AFT FLOAT SKIDTUBE PROTECTOR

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR
ASTM A36/A366/A1008 OR
CSA G40-21, 38W/44W/50W/60W/70W SERIES
COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6)
PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

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51718

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

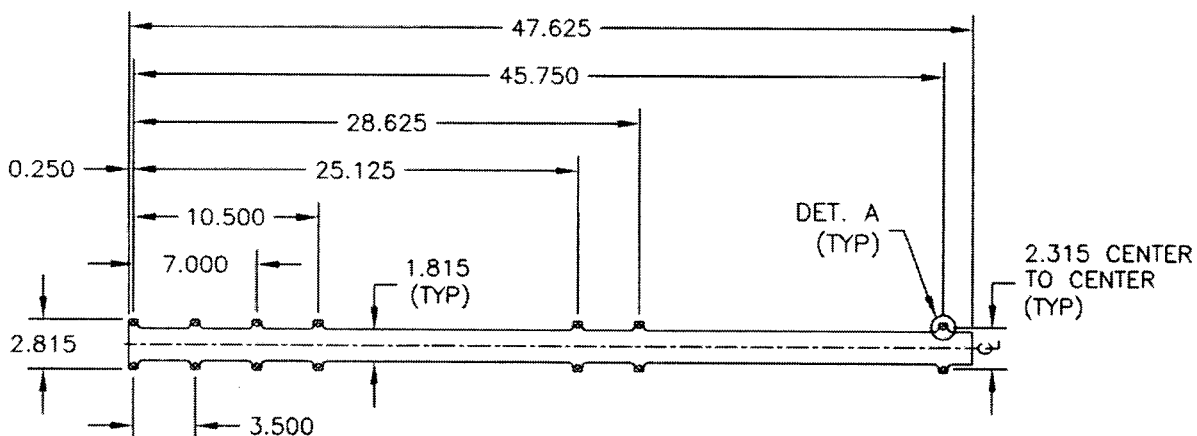
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

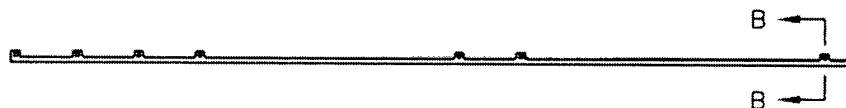


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3340	REV. B SHEET 10 OF 11
DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:10



D3340-25F FLAT PATTERN

RELEASED
05.11.28 *[Signature]*



D3340-25 FORWARD SKIDTUBE PROTECTOR

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR
ASTM A36/A366/A1008 OR
CSA G40-21, 38W/44W/50W/60W/70W SERIES
COLD ROLLED STEEL 19 GAUGE (0.040 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6)
PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP CORNERS 0.063 MAX

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51419

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

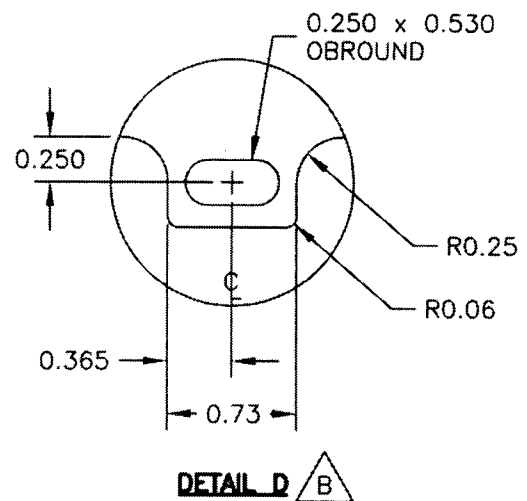
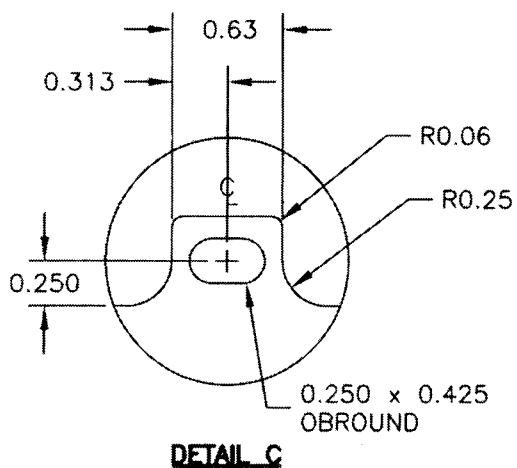
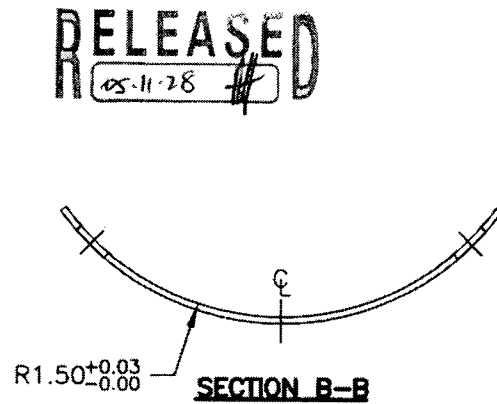
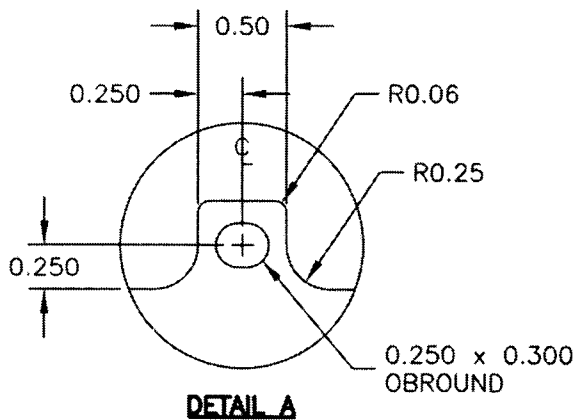
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3340	REV. B SHEET 11 OF 11
DATE 05.11.22		TITLE SKIDTUBE PROTECTOR	SCALE 1:1



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5118

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries